

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-003244**Date Inspected:** 06-Jul-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Keng Chan**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date, Caltrans Office of Structure Materials (OSM) Quality Assurance Inspector (QA) Raymond Lara is present at the jobsite in Zhenhua Port Machinery Company facility on Changxing island, China for the purpose of observing and monitoring the fabrication of the SAS Superstructure.

Bay 1

The Quality Assurance Inspector observed ZPMC welder 052917, utilizing the flux cored arc welding process on a complete joint penetration in the flat position on longitudinal stiffener weld number ESDI SA216 F/K 11A. The Quality Assurance Inspector observed ZPMC Quality Control Personnel record parameters and verify preheat temperatures. The welding parameters observed by the Quality Assurance Inspector appeared to be within welding procedure specification WPS-B-T-2221-B-U3-F.

Skin Plate A South Tower Assembly

The Quality Assurance Inspector observed ZPMC in process of performing fit up operations on longitudinal stiffeners to skin plate A South Tower Assembly. The Quality Assurance Inspection observed the root gap on the longitudinal stiffener to skin plate fit up appeared to be less than 1 mm. See digital photograph below.

Bay 2**Skin Plate A East Tower Assembly**

The Quality Assurance Inspector observed ZPMC in process of performing fit up operations on longitudinal stiffeners to skin plate A East Tower Assembly. The Quality Assurance Inspection observed the root gap on the longitudinal stiffener to skin plate fit up appeared to be less than 1 mm. The Quality Assurance Inspector

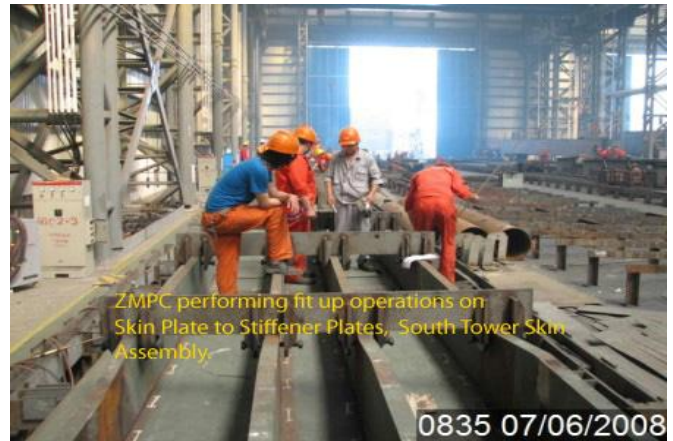
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observed ZPMC utilize a counter weight as a fit up aid.

The Quality Assurance Inspector observed ZPMC performing thermal cutting operations on diaphragm plate SA234, elevation 28m.

The Quality Assurance Inspector verified 45 degree bevel angles on longitudinal stiffener plate P503A. See digital photograph below.



Summary of Conversations:

American Bridge/Fluor Quality Assurance Manager Don Walton informed the Quality Assurance Inspector, ZPMC will be focusing on the production welding on tower skin plate B and E.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, (707) 649-5453, who represents the Office of Structural Materials for your project.

Inspected By:	Lara, Raymond	Quality Assurance Inspector
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Reviewed By:	Lanz, Joe	QA Reviewer
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